

Date:
User:Thursday, 12/7/2006 4:32:28 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 407 BASKET BASE ASSEMBLY		
Job Number	: 29832A					
Estimate Number	: 10912					
P.O. Number	: N/A			Part Number	: D2948041	
This Issue	: 12/7/2006 S.O. No. : N/A			Drawing Number	: D2948 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 21174A			Material	: N/A	
Written By	: <u> </u>			Due Date	: 12/19/2006	
Checked & Approved By	: <u> </u> 06 12 07			Qty:	1 Um: Each	
Comment	: Est Rev:E 04.08.09 Revised Step 1 KJ/JLM					

Additional Product

Job Number:

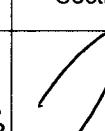
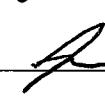
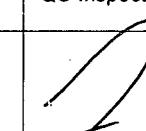


Seq. #: Machine Or Operation: Description :

1.0	M304TR0750W049	304 RD Tube .750 x .049W			50FT. 5x120"
		Comment: Qty.: 48.9993 f(s)/Unit Total : 48.9993 f(s) Material: 304/316 SS tube 0.049" wall (M304TS0.750W.049) Batch: M19161	DP 6-12-13		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1			DP 6-12-13
3.0	BENDING	BENDING MACHINE			DP 6-12-13
	Comment: BENDING MACHINE	Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio FT019			DP 6-12-13
4.0	QC5	INSPECT WORK TO CURRENT STEP			DP 06-12-14
5.0	D23273	Spacer Bushing			DP 06-12-14
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	1 D2327-3 Spacer 628597			DP 06-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/12/20
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/13	3.0	1x D2946-5 over bent in bender.	 QSI 0412 06-12-20 	re-adjust program for bender. Cut off the resulting part enlarge end of the mat'l, and I.O. and place back into stock for x-members in the baskets.	 06-12-13	 06-12-13	 QSI 0412 06-12-20 	 06-12-13

NOTE: Date & initial all entries

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Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 29832A

Part Number: D2948041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2581 Mounting Bracket

Batch

B28915

PD 06-12-18

7.0 D2954 Mounting Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D2954 Mounting Plate B12525

PD 06-12-18

8.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch
32sf M304EX0.75-16F SS Expanded Metal B1102394

PD 06-12-18

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Trim to length as per Dwg D2948 and Deburr/Identify as D2948-5

2-Cut 3/4" x 3/4" square tubing as per Dwg D2948

Identify properly as D2948-1/-3/-7/-9

3-Renove all Markings From Material.

4-Weld as per Dwg D2948 and QSI 004. Deburr as required.

A/R SS Rod Batch: M101744

PD 06-12-18

10.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/19 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #: Machine Or Operation:

Description :

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/12/19 (1)

12.0 POWDER COATING

POWDER COATING



M 102391

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m/M-B 06/12/19 (1)

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION.

SAD 06/12/19 (1)

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G1A

SB 06/12/19 (1)

15.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1) 06/12/20

Job Completion



u 06-12-20

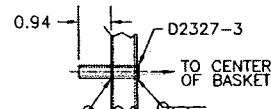
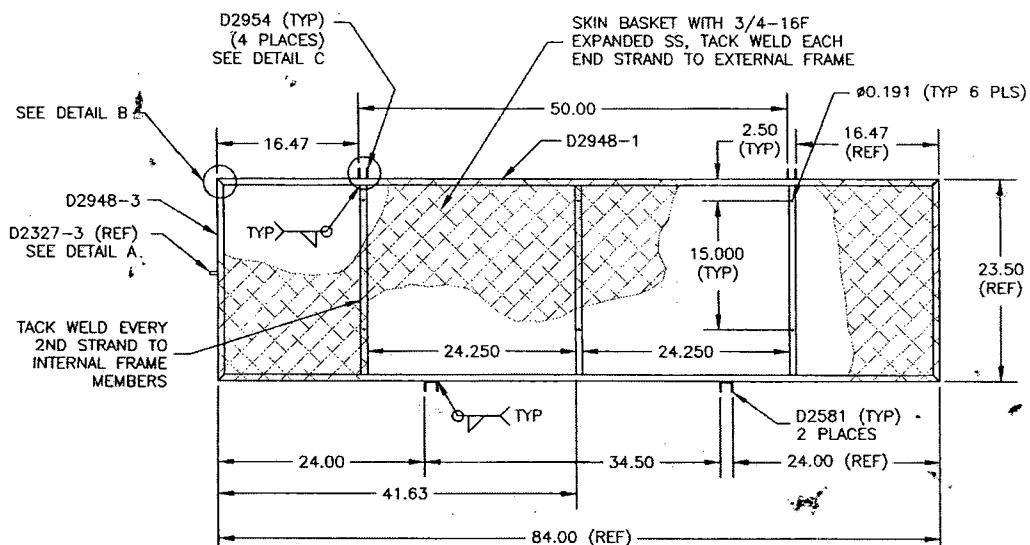
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

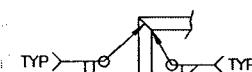
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

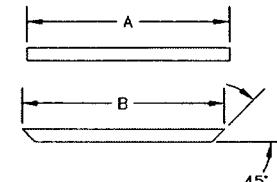
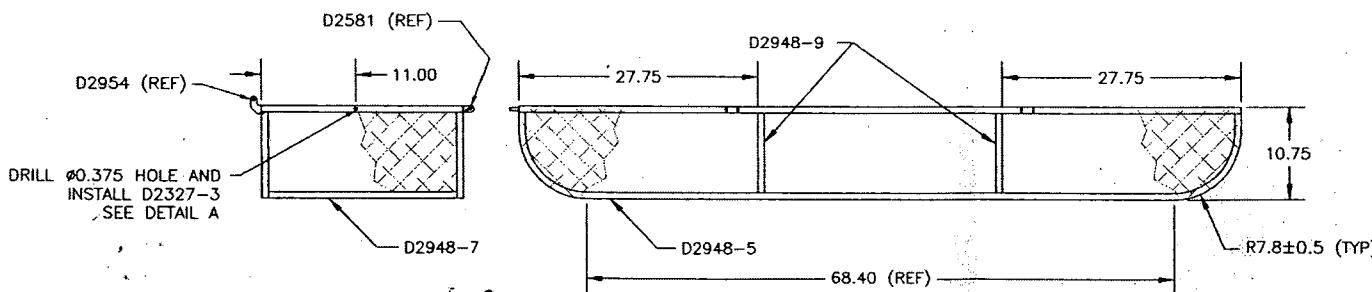
RELEASED
00.07.18



DETAIL A
SPACER INSTALLATION



DETAIL B
WELD ALL JOINTS
AS SHOWN



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
1	D2948-041	BASKET ASSEMBLY	N/A	N/A
2	D2948-1	FRAME MEMBER	N/A	84.00
2	D2948-3	FRAME MEMBER	N/A	23.50
2	D2948-5	FRAME MEMBER	95.97	N/A
3	D2948-7	FRAME MEMBER	22.00	N/A
4	D2948-9	FRAME MEMBER	9.25	N/A
1	D2327-3	SPACER	N/A	N/A
2	D2581	MTG BRACKET	N/A	N/A
4	D2954	MOUNTING PLATE	N/A	N/A

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.049 WALL SQUARE TUBING
MESH MATERIAL: 3/4-16F EXPANDED SS
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
WELD PER DART QSI 004
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER NO. 29832A
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B	00.07.17	ADD Ø0.191; R7.8 WAS R6.8
A	00.01.12	NEW ISSUE
DESIGN	DRAWN BY	DART
RF	RF	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. 02948 REV. B SHEET 1 OF 1
DATE		TITLE BASKET BASE ASSEMBLY NTS
00.07.17		

